

ID Turning tool with dxQ Profile

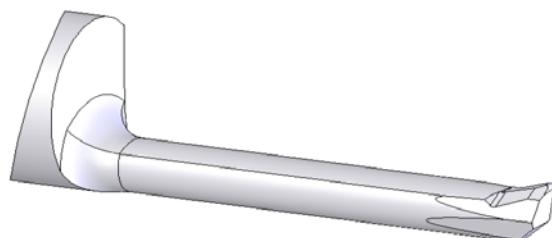
A17-010

This turning tool with excentric shaft is used for turning small pieces on high precision lathe machines.

The

tool is ground out of a blank with Ø4x37mm.

The excentric profile grinding option of Quinto allows to grind the excentric shaft based on DXF. The main profile is ground with dxQ operations of Quinto.



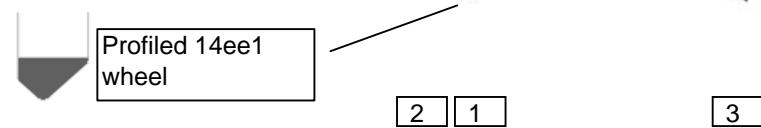
1. Cycletime for Production

Workpiece:	Diameter 4 mm, Z 1, Length 11 mm Material CARBIDE						
Operations	Probe	SideFlats	CuttingFace	2nd Clear.	Profile finish.	Profile polish	Excentric
Feed [mm/Min]	2000	50	100	40	40	40	600
No. Of cycles		5	1	1	1	1	1
Cutting feed [m/s]		22	22	22	22	22	24
Used wheels		2	2	3	3	3	1
Grinding time [s]	6	80	20	19	19	20	201
Total cycle time	06 Min 05 sec						

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	14ee1 Ø125 D64
2	11V9 Ø75 D64
3	1V1 Ø125 D46



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG / SIRIUS HPM

Coolant: Synthetic Oil, pressure 6 bar

Control: Fanuc 320i

Software: Quinto 5

Accessories: STL6051

Responsible engineer: HEM, 31.03.2011

www.schneeberger.ch

J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland

Subsidiaries in: France, Deutschland, Italia, United States, UK, China

**TECHNOLOGY
FOR TOOLING**